

Work Order ID 66658

Wednesday, February 23, 2011 1:10:36 PM



Page 1

Item ID: D120-639-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Tungsten Carbide Wearplate

Start Date: 2/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/02/23 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9223	Rev A
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IIN-D120-639	Rev A
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100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D120-639-011 CHG 002

8/10/17for BG 11-3-16 (2)

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/17 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66658

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Item ID: D120-639-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Tungsten Carbide Wearplate

Start Date: 2/23/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/03/17

(2)

120

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package and Identify as per PPP D120-639-011

NEEF

Loc 33

6/3/17 (2)

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/18

11-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66658

Parent Item: D120-639-011

Parent Item Name: Tungsten Carbide Wearplate

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 2.00

Required Qty: 2.00

ALS7-1032-130

Purchased

No

105

Each

1,814.000

36

72



Insert



M116864 1/3/17 SP

Location

Loc Qty

Loc Code

FP 21
115079 21
ST282 1793
111529 32
113238 17
115502 500
115581 244
116800 1000

105

Each

37.0000



10

1/3/17

D2648-3

Manufactured

No



Wearpad

Location

Loc Qty

Loc Code

FG 12
45316 12
FP016 24
65824 24
FP17 1
59595 1

105

Each

1,222.000



80

1/3/17

MS27039-1-08

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST291 1222
110835 367
115108 855

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:10:33 PM

Page 3

Work Order ID: 66658

Parent Item: D120-639-011

Parent Item Name: Tungsten Carbide Wearplate

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 2.00

Required Qty: 2.00

8 72 AN960JD10L NAS1149D0332J Purchased No 105 Each 6.0000
Washer

40 80
11/17/10 11/3/11

S2 MS27130-S30 Purchased No 105 Each 224.0000
Insert

4 8
11/3/17 5/12/11

Location	Loc Qty	Loc Code
ST335	6	
11912	6	

Location	Loc Qty	Loc Code
ST293	224	
100154	224	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE

32.2 WEIGHT AND BALANCE

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

32.4 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
1	1	D2746	WEARPLATE
1	1	D2656-31	WEARPLATE
1	1	D2656-13	WEARPLATE
5		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
40	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
40	40	MS27039-1-08	SCREW
40	40	AN960JD10L	WASHER



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

REFERENCE ONLY

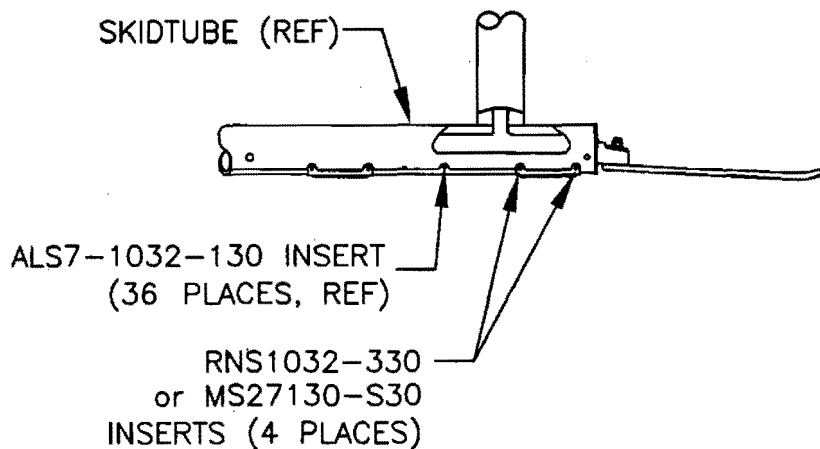
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT



NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD
OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: NOV 19, 2001
CERT. NO.: SH01-25
ISSUE NO.: 1

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